54535

Work Order ID 52401

September 22, 2009 11:32:34 AM

Item ID: D3849-041
Revision ID: B
Item Name: FWD WEARPLATE ASSY, STD/FLOAR GEAR
Start Date: 09/23/2009 **Start Qty:** 2.00
Required Date: 10/02/2009 **Req'd Qty:** 2.00
Reference:

Accept

Setup Start
Stop

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** MF **Date:** 09-09-22 **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**: D3849 / B									
100		0.00							
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3849 Dwg Rev: B Prog Rev: B 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00							
Quality Control									

HB 9-9-30

HB 9-9-30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 52401

September 22, 2009 11:32:34 AM

Item ID: D3849-041
Revision ID: B
Item Name: FWD WEARPLATE ASSY, STD/FLOAR GEAR
Start Date: 09/23/2009 **Start Qty:** 2.00
Required Date: 10/02/2009 **Req'd Qty:** 2.00
Reference:

Accept **Setup Start** **Stop**

Cust Item ID:
Customer:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00				(+2)	0		
QC	**Memo**	0.00							
Quality Control									
130		0.00				2	0		
Brake NC	**Memo**	0.00							
Brake NC	Form as per dwg using DT8179 & DT8155								
140	QC5- Inspect part completeness to step on W/O	0.00				2			
QC	**Memo**	0.00							
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 52401

September 22, 2009 11:32:34 AM

Item ID: D3849-041 **Accept** **Setup Start** **Stop**

Revision ID: B

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Start Date: 09/23/2009 **Start Qty:** 2.00 **Cust Item ID:**

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Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
Large Fab	**Memo**	0.00							
Large Fab	1- On D3901-1 bar, fill cut outs with hardcoat welding rod as per dwg D3849 2059 B Hardcoat Welding Rod BATCH#: M112963								
	2- Weld D3901-1 bar to wearplate by positioning holes together as per dwg D3849 304 S.S. Welding Rod BATCH #: M102421								
160	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	**Memo**	0.00							
Quality Control									

EL 9-12-2 XD

AD 09.1203 (5)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 52401

September 22, 2009 11:32:34 AM

Item ID: D3849-041 **Accept** **Setup Start** **Stop**

Revision ID: B

Item Name: FWD WEARPLATE ASSY, STD/FLOAR GEAR

Start Date: 09/23/2009 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 10/02/2009 **Req'd Qty:** 2.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00				(2)	4		
180 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 M 112588. **Memo** START TIME: 11:45 OVEN TEMPERATURE: 320° FINISH TIME: 12:15	0.00 0.00 BK 09-12-3				(2).			
190 QC Quality Control	QC3- Inspect Part Finish **Memo**	0.00 0.00				(2) 0			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 52401

September 22, 2009 11:32:34 AM

Item ID: D3849-041 **Accept** **Setup Start** **Stop**

Revision ID: B

Item Name: FWD WEARPLATE ASSY, STD/FLOAR GEAR

Start Date: 09/23/2009 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 10/02/2009 **Req'd Qty:** 2.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200		0.00				2	0		
Small Fab	**Memo**	0.00							
Small Fab	1- Bond D3848-1 gasket to inner surface of wearplate using a thin layer of 3m 1300/1300L scotch grip adhesive as per dwg BATCH: M113174					8 09/12/02			
210	QC5- Inspect part completeness to step on W/O	0.00				2	0		
QC	**Memo**	0.00				=> 8 09/12/04			
Quality Control									
220	Identify as per dwg & Stock Location: 178	0.00							
Packaging	**Memo**	0.00				09/14/7			
Packaging						2			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
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NOTE: Date & initial all entries

Work Order ID 52401

September 22, 2009 11:32:34 AM

Item ID: D3849-041
Revision ID: B
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Accept

Setup Start
Stop

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00						09/12/11	
Quality Control									

MF
09-12-11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

September 22, 2009 11:32:34 AM

Work Order ID: 52401

Parent Item: D3849-041RevB

Parent Item Name: FWD WEARPLATE ASSY, STD/FLOAR GEAR

Start Date: 09/23/2009 **Required Date:** 10/02/2009

Comments:

Start Qty: 2.00 **Required Qty:** 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3848-1RevB		Manufactured	No				Each	0.0000	2.0000			
GASKET												
D3901-1RevB		Manufactured	No				Each	4.0000	2.0000			
Bar												
M304S18GA		Purchased	No				sf	183.4395	5.1579			
304/316 .050 Sheet												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
WA	4	
51841	4	

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
MAT	183.4395053	
108156	0.98526316	
111743	23.7174	
112178	158.736842	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	SJ401
Description: FWD WEAR PLATE ASSY	Part Number:	D3849-041
Inspection Dwg: D3849-1 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

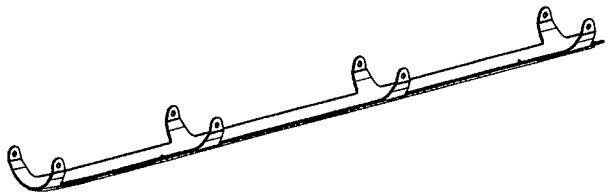
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .188	+.005 -.001	.191	✓			
Ø .375	+.006 -.001	.378	✓			
5.89	+/- .030	5.890	✓			
18.000	+/- .010	18.000	✓			
36.000	+/- .010	36.000	✓			
51.313	+/- .010	51.313	✓			
2.45	+/- .030	2.451	✓			
2.433	+/- .010	2.431	✓			
6.642	+/- .010	6.640	✓			
4.38	+/- .030	4.378	✓			
7.00	+/- .030	6.997	✓			
4.00	+/- .030	4.002	✓			
34.560	+/- .010	34.550	✓			
54.26	+/- .030	54.260	✓			
7.77	+/- .030	7.710	✓			
.060	+/- .010	.058	✓			

Measured by:	IB
Date:	9-9-30

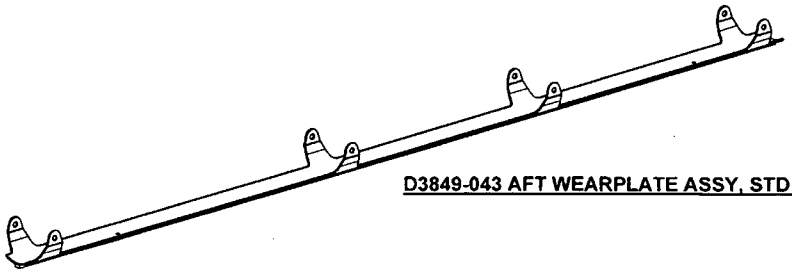
Audited by:	S
Date:	09/01/30

Prototype Approval:	N/A
Date:	N/A

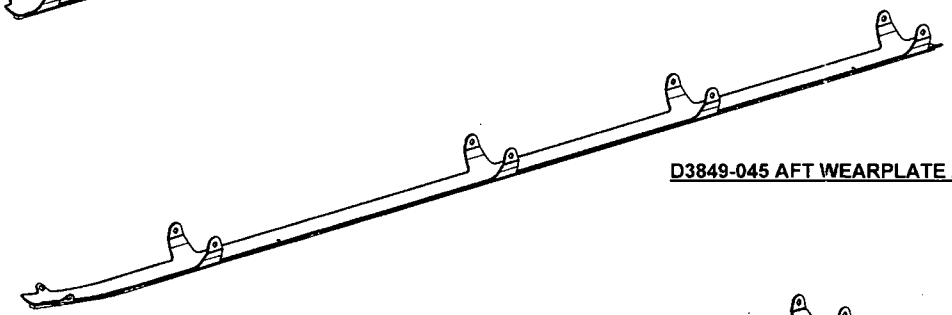
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



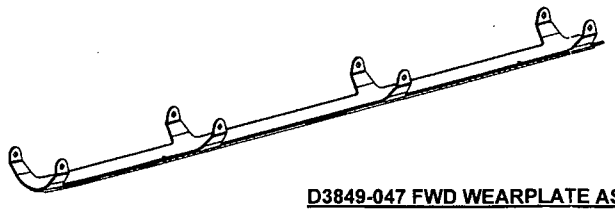
D3849-041 FWD WEARPLATE ASSY, STD GEAR



D3849-043 AFT WEARPLATE ASSY, STD GEAR



D3849-045 AFT WEARPLATE ASSY, FLOAT GEAR



D3849-047 FWD WEARPLATE ASSY, FLOAT GEAR (B)

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3849-041	FWD WEARPLATE ASSY, STD GEAR
2		X			D3849-043	AFT WEARPLATE ASSY, STD GEAR
3			X		D3849-045	AFT WEARPLATE ASSY, FLOAT GEAR
4				X	D3849-047	FWD WEARPLATE ASSY, FLOAT GEAR
11	1				D3849-1	PLATE
12		1			D3849-3	PLATE
13			1		D3849-5	PLATE
14				1	D3849-7	PLATE
15	1				D3848-1	GASKET
16		1			D3848-3	GASKET
17			1		D3848-5	GASKET
18				1	D3848-7	GASKET
19	1				D3901-1	BAR
20		1			D3901-3	BAR
21			1		D3901-5	BAR
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

#52401

RELEASED 9/07/5M

REV.	DESCRIPTION	BY	DATE
B	REVISED FLAT PATTERN Ø0.375 WAS SLOT HOLE ON D3849-1F/-3F/-5F (ZN A4-5,B4-7, B4-8, C2-10, B2-10); ADD D3849-047 (ZN D4-1, A4-1 & B4-5) & D3849-7/-7F (ZN C4-9, A4-9); ADD SECTION K-K (ZN C5-10); 0.88 WAS 0.875 & 0.44 WAS 0.438 (ZN A3-10); ADD 0.25 & 0.88 (ZN D4-10, D3-10); ADD 0.88 & 0.44 (ZN C3-10 & B3-10); ADD FLAG NOTE (ZN A8-2, C6-2, C3-2, A8-3, C6-3, C3-3, A8-4, C6-4, C2-4); 66.87 WAS 67.36 (ZN B4-7)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.		D3849	SHEET 1 OF 10
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	09.06.30		

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

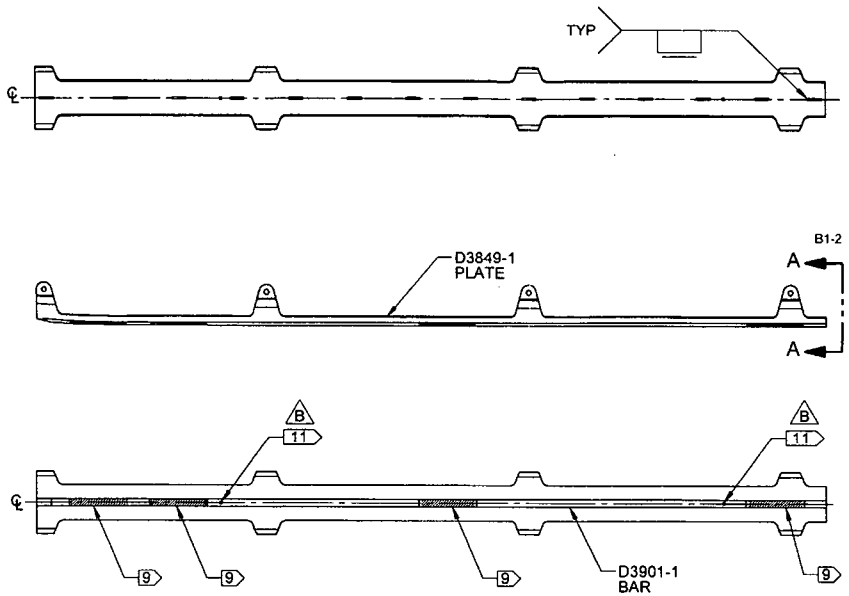
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

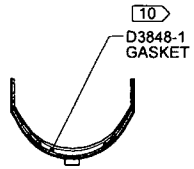
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

#52401



D3849-041 FWD WEARPLATE ASSY, STD/FLOAT GEAR (B)



SECTION A-A C3-2
SCALE 2X

RELEASED
09/07/13

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-041" USING YELLOW PAINT MARKER AT INSIDE SURFACE
7) WEIGHT: D3849-041 = 4.24 lbs
8) WELDING: PER QSI 004
9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3901-1 BAR ON ALL 3 SURFACES
10) AFTER FINISH, BOND D3848-1 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
(B) 11) TRANSFER DRILL Ø0.188 HOLES FROM D3849-1 PLATE TO D3901-1 BAR

DESIGN	RF	DART AEROSPACE USA, INC.
DRAWN	RF	PORT HADLOCK, WA
CHECKED	RF	DRAWING NO. D3849 REV. B
MFG. APPR.		SHEET 2 OF 10
APPROVED		TITLE WEARPLATE ASSY SCALE NTS
DE APPR.		
DATE	09.06.30	

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

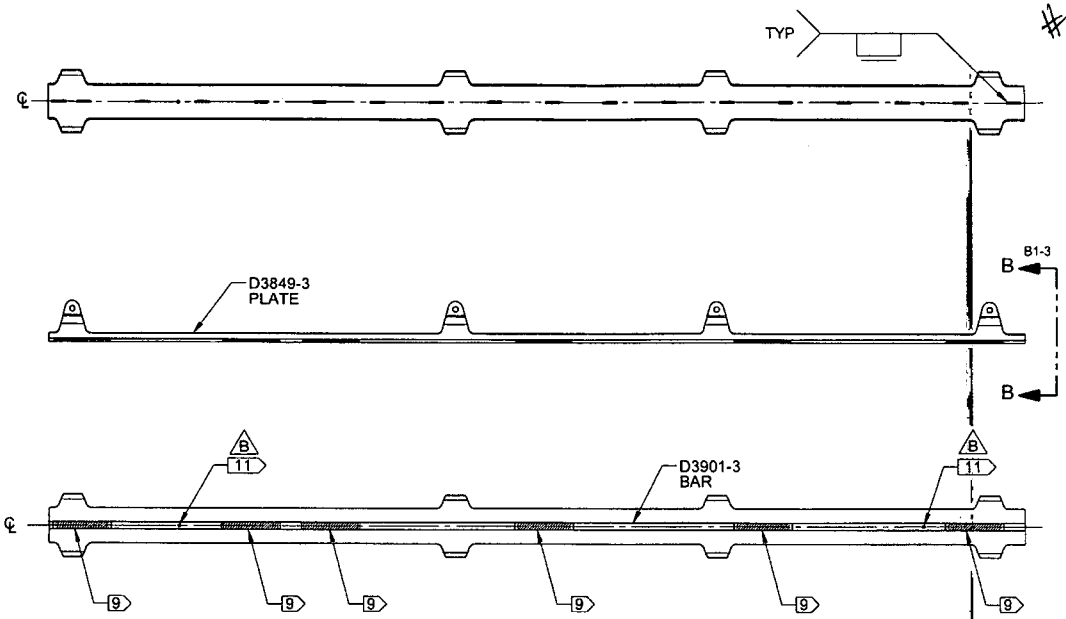
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

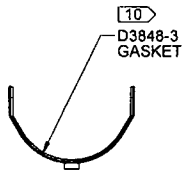
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

#52401





SECTION B-B C2-3
SCALE 2X

D3849-043 AFT WEARPLATE ASSY, STD GEAR

RELEASED
9/10/15 MM

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-043" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: D3849-043 = 5.21 lbs
8) WELDING: PER QSI 004
9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3901-3 BAR ON ALL 3 SURFACES
10) AFTER FINISH, BOND D3848-3 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
△B 11) TRANSFER DRILL Ø0.188 HOLES FROM D3849-3 PLATE TO D3901-3 BAR

DESIGN	RF	DART AEROSPACE USA, INC.
DRAWN	RF	PORT HADLOCK, WA
CHECKED		DRAWING NO. D3849 REV. B
MFG. APPR.		SHEET 3 OF 10
APPROVED		TITLE WEARPLATE ASSY SCALE NTS
DE APPR.		
DATE	09.06.30	

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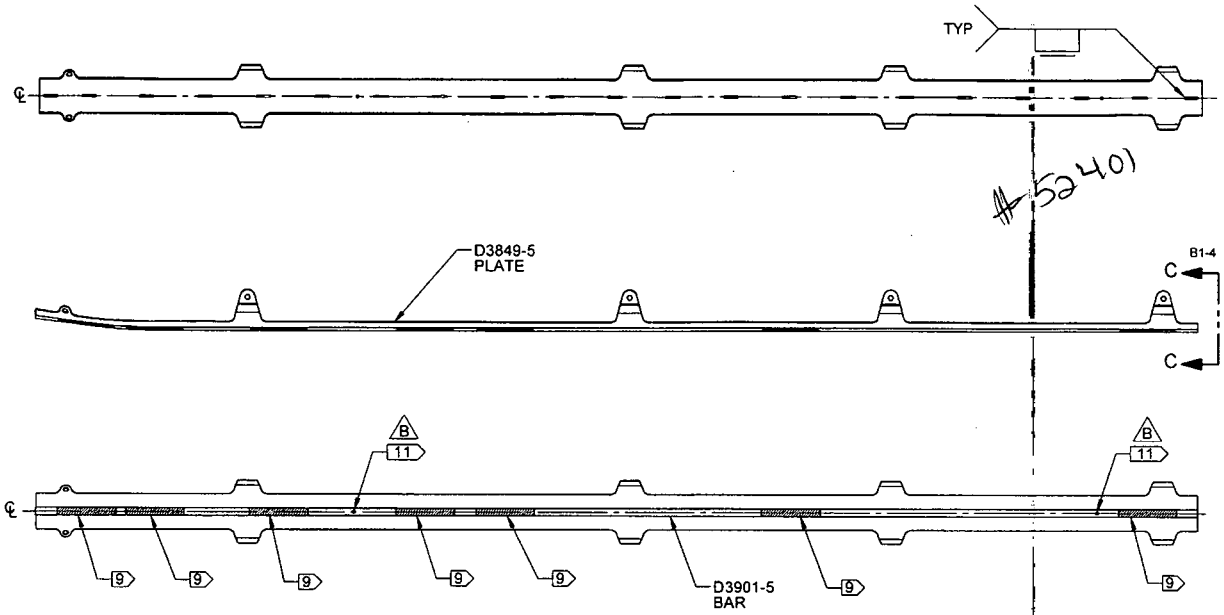
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

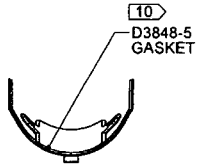
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries



#52401



SECTION C-C C2-4
SCALE 2X

D3849-045 AFT WEARPLATE ASSY, FLOAT GEAR

RELEASED 09/6/15 MM

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-045" USING YELLOW PAINT MARKER AT INSIDE SURFACE
7) WEIGHT: D3849-045 = 5.98 lbs
8) WELDING: PER QSI 004
9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3849-5 BAR ON ALL 3 SURFACES
10) AFTER FINISH, BOND D3848-5 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
(B) 11) TRANSFER DRILL Ø0.188 HOLES FROM D3849-5 PLATE TO D3901-5 BAR

DESIGN	RF	DART AEROSPACE USA, INC.
DRAWN	RF	PORT HADLOCK, WA
CHECKED		DRAWING NO. D3849 REV. B
MFG. APPR.		SHEET 4 OF 10
APPROVED		TITLE WEARPLATE ASSY SCALE NTS
DE APPR.		
DATE	09.06.30	

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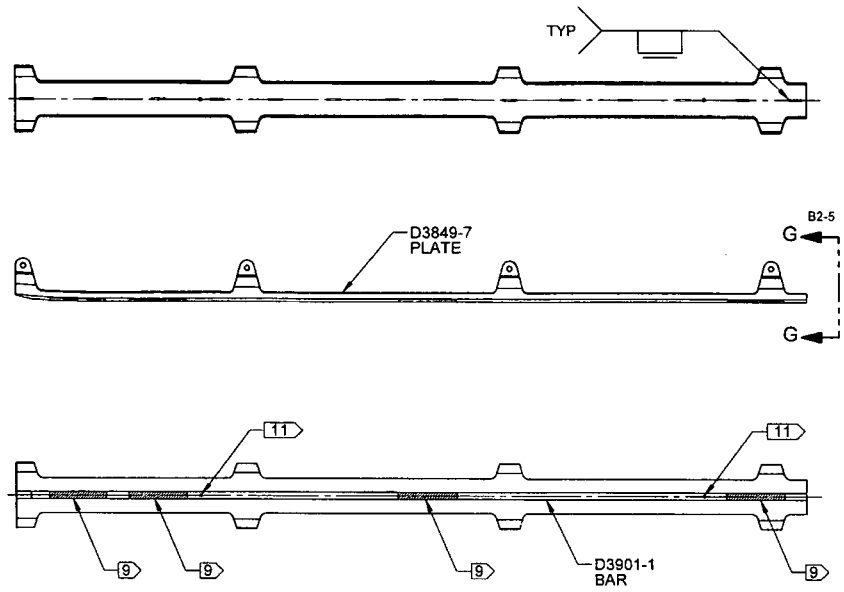
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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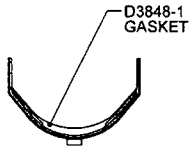
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries



#52401

D3849-047 FWD WEARPLATE ASSY, FLOAT GEAR (B)



SECTION G-G C3-5
SCALE 2X

RELEASED
09/07/15 MM

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-047" USING YELLOW PAINT MARKER AT INSIDE SURFACE
7) WEIGHT: D3849-047 = 4.26 lbs
8) WELDING: PER QSI 004
9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3901-1 BAR ON ALL 3 SURFACES
10) AFTER FINISH, BOND D3848-7 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
11) TRANSFER DRILL Ø0.188 HOLES FROM D3849-7 PLATE TO D3901-1 BAR

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA
DRAWN	RF	
CHECKED	AF	DRAWING NO. D3849 REV. B
MFG. APPR.	EF	SHEET 5 OF 10
APPROVED	AM	TITLE WEARPLATE ASSY SCALE NTS
DE APPR.	AM	
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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

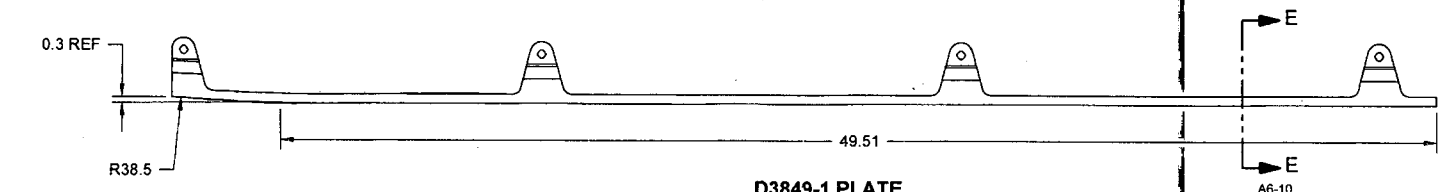
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Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

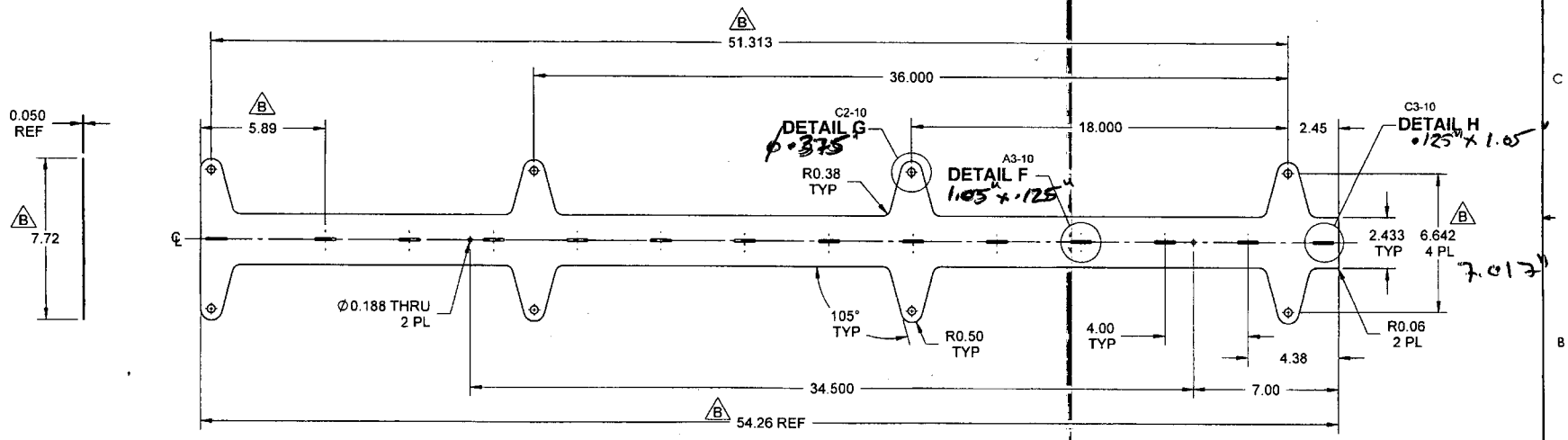
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

#52401



D3849-1 PLATE
(MAKE FROM D3849-1F)



D3849-1F FLAT PATTERN B

RELEASED
09/10/15 MM

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 2.33 lbs

DESIGN	RF	DART AEROSPACE USA, INC.
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CHECKED	AT	DRAWING NO. D3849 REV. B
MFG. APPR.		SHEET 6 OF 10
APPROVED		TITLE WEARPLATE ASSY SCALE NTS
DE APPR.		
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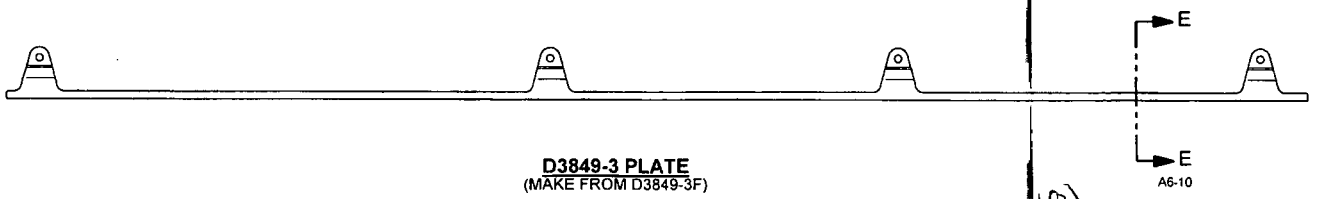
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

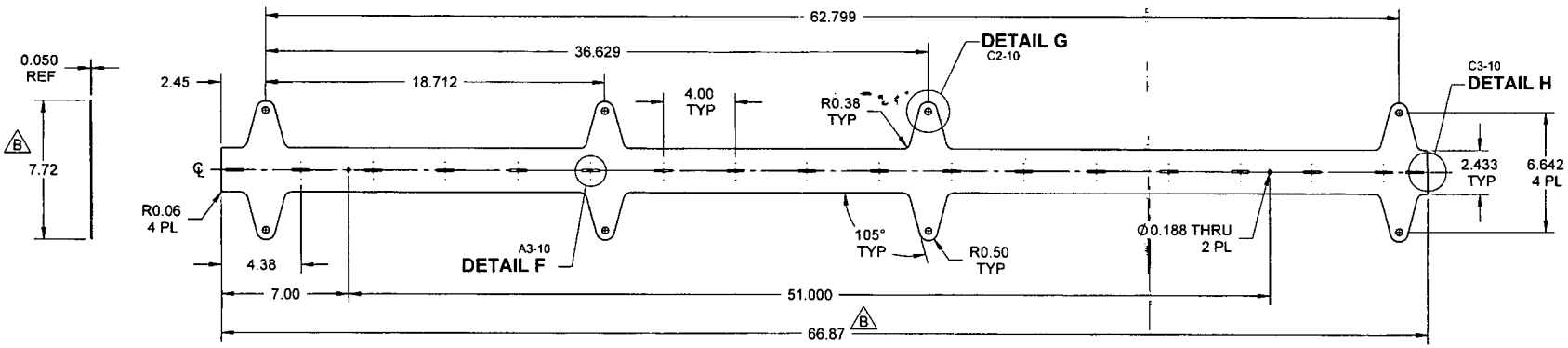
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DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries



D3849-3 PLATE
(MAKE FROM D3849-3F)

#52401



D3849-3F FLAT PATTERN B

RELEASED
09/07/15

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 2.82 lbs

DESIGN	RF	DART AEROSPACE USA, INC.
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MFG. APPR.		SHEET 7 OF 10
APPROVED		TITLE WEARPLATE ASSY SCALE NTS
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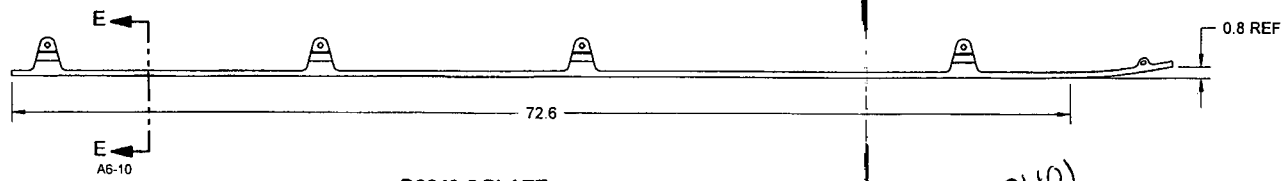
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DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

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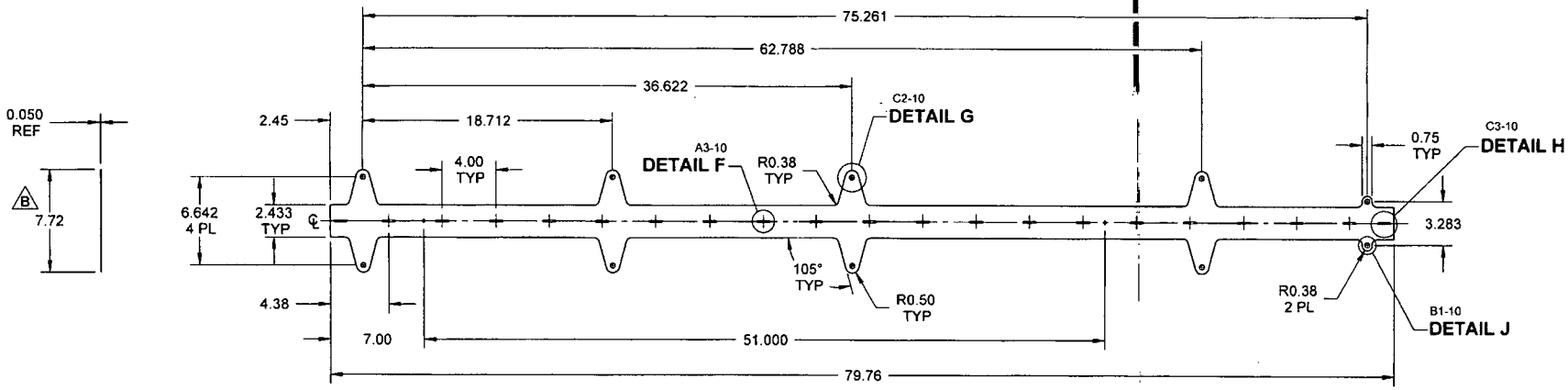
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries



D3849-5 PLATE
(MAKE FROM D3849-5F)

#52401



D3849-5F FLAT PATTERN (B)

RELEASED
9/07/15 MM

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 3.30 lbs

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MFG. APPR.		SHEET 8 OF 10
APPROVED		TITLE WEARPLATE ASSY SCALE NTS
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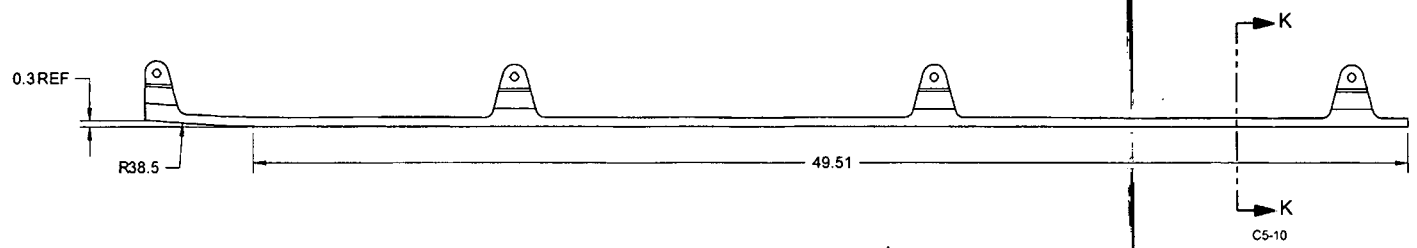
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DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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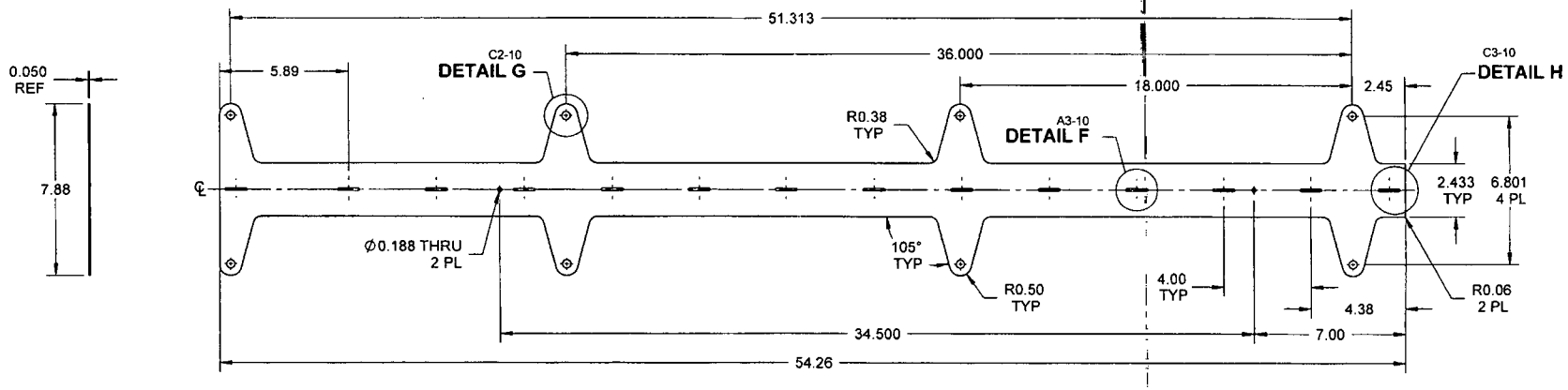
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DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries



D3849-7 PLATE (B)
(MAKE FROM D3849-7F)

#52401



D3849-7F FLAT PATTERN (B)

RELEASED 09/07/15 MC

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 2.34 lbs

DESIGN	RF	DART AEROSPACE USA, INC.
DRAWN	RF	PORT HADLOCK, WA
CHECKED		DRAWING NO. D3849 REV. B
MFG. APPR.		SHEET 9 OF 10
APPROVED		TITLE WEARPLATE ASSY SCALE NTS
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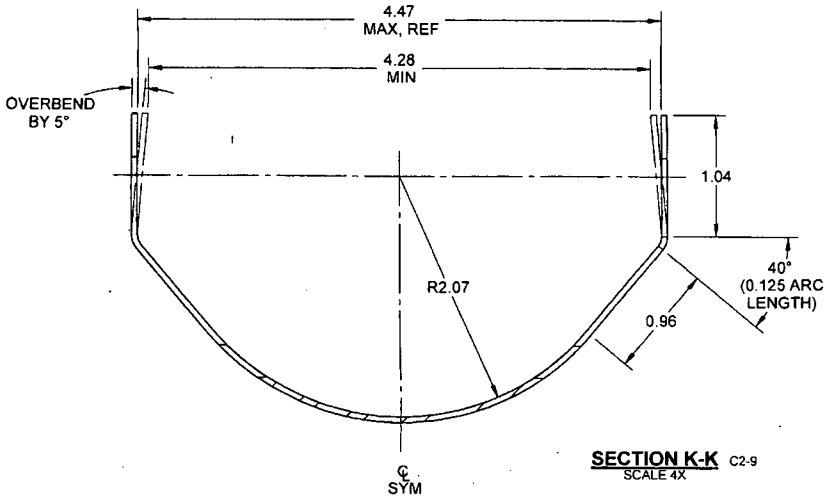
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DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

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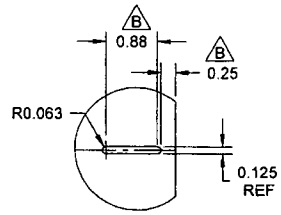
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

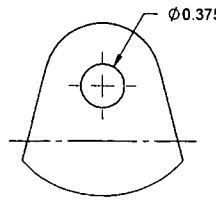
NOTE: Date & initial all entries



SECTION K-K C2-9
SCALE 4X

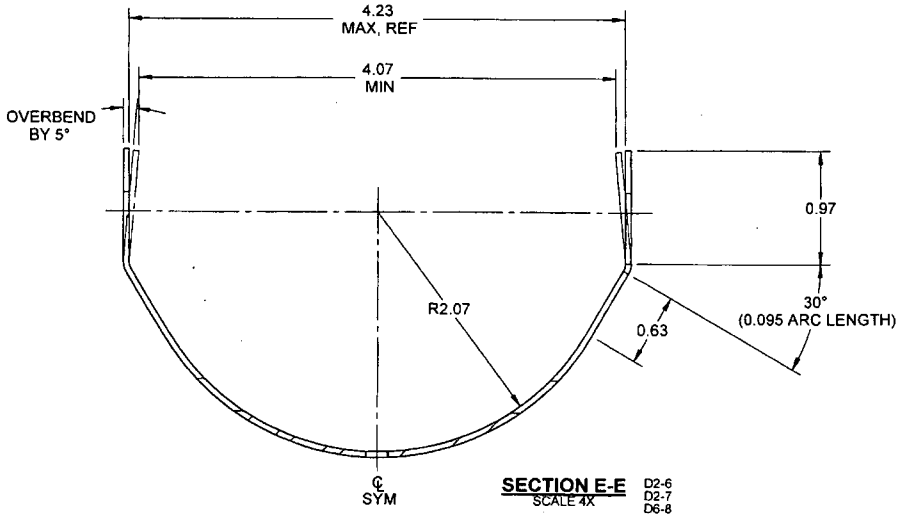


DETAIL H C1-6 C1-7 C1-8 C1-9
SLOT DETAIL TYP
SCALE 2X

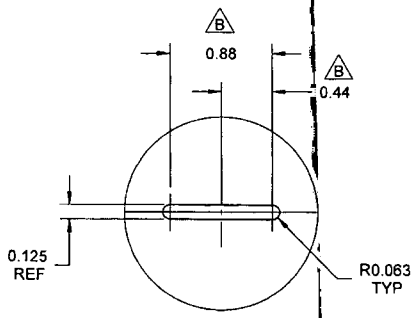


DETAIL G C4-6 C4-7 C4-8 C6-9
SLOT DETAIL TYP
SCALE 4X

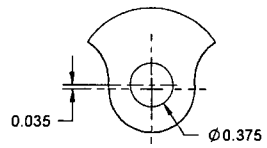
#52401



SECTION E-E D2-6 D2-7 D6-8
SCALE 4X



DETAIL F C3-6 B6-7 C5-8 B3-9
SLOT DETAIL TYP
SCALE 4X



DETAIL J B1-8
DETAIL TYP
SCALE 8X

RELEASED
09/07/15

DESIGN	RF	**DART AEROSPACE USA, INC.** PORT HADLOCK, WA
DRAWN	RF	
CHECKED		DRAWING NO. D3849 REV. B
MFG. APPR.		SHEET 10 OF 10
APPROVED		TITLE WEARPLATE ASSY SCALE NTS
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DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries